

Work Order ID 85191

June-04-12 1:30:12 PM

\*85191\*

Page 1

Item ID: D350-636-215

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube STD LH, Deluxe

Start Date: 04/06/2012 Start Qty: 1.00 \*1\*

Required Date: 18/06/2012 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals:	Process Plan:	MLJ	Date:	12/06/09	Tooling:	Date:	Run	Start	*NR1*
	QC:		Date:		SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-636	I	54							
100		0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-636-215 CHG003		DAS	16	9-09	17/06/09			12-8-8
110	Assemble as per dwg	0.00							
*110*									
HandFinish	Memo	0.00							
Hand Finishing	1- Assemble Toe kit, Wedge kit and Tow ring kit to D350-636-015 as per IIN-D350-636 page:15-16-17-20								
120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00	DAS	16	9-09	17/06/09			
Quality Control									

B85191

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 85191**

June-04-12 1:30:12 PM

\*85191\*

Page 2

**Item ID:** D350-636-215

Accept

\*N900040100\*

Setup Start

\*NS1\*

**Revision ID:**

**Item Name:** Skidtube STD LH, Deluxe

Stop

\*NS2\*

**Start Date:** 04/06/2012 **Start Qty:** 1.00 **\*1\***

Cust Item ID:

**Required Date:** 18/06/2012 **Req'd Qty:** 1.00 **\*1\***

Customer:

**Reference:**

<b>Approvals:</b>	<b>Process Plan:</b> _____	<b>Date:</b> _____	<b>Tooling:</b> _____	<b>Date:</b> _____	<b>Run</b>	<b>Start</b>	<b>*NR1*</b>
	<b>QC:</b> _____	<b>Date:</b> _____	<b>SPC (Y/N):</b> _____	<b>Date:</b> _____	<b>Stop</b>		<b>*NR2*</b>

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
150 <b>*150*</b> Packaging	Memo	0.00							12/8/98
Packaging	Identify and pack for shipping as per PPP D350-636-215 Location: <u>72</u> PPP rev: _____								
160 <b>*160*</b> QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							12/8/13 (J)
	Memo	0.00							

12-08-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

June-04-12 1:30:16 PM

Page 1  
10

Work Order ID: 85191

\*85191\*  
\*D350-636-215\*

Parent Item: D350-636-215

Parent Item Name: Skidtube STD LH, Deluxe

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.04 new issue DD verf:EC  
11.04.14 ecn11-553 DD verf:EC  
AS PER ECN 12-542 DD verf:EC

IPP Rev:B  
IPP Rev:C 112.04.16

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-636-015		Manufactured	No			110	Each	1.0000	1	1			**

\*D350-636-015\*  
Skidtube STD w/ Training Wearplates, LH

Location	Loc Qty	Loc Code
----------	---------	----------

FG	1	
64951	0	
81399	1	

D350-636-101  
Manufactured No

\*D350-636-101\*  
Toe Step, LH/RH

Location	Loc Qty	Loc Code
----------	---------	----------

FG120	24	
71606	6	
82678	18	

D350-636-105A  
Manufactured No

\*D350-636-105A\*  
Wedge Installation

Location	Loc Qty	Loc Code
----------	---------	----------

FG120	10	
51959	1	
67317	4	
71604	1	
77147	4	

B85146 (x1) 4/6/2013

B85188 (v1) 4/6/2013

Y1 4/6/2013

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

June-04-12 1:30:16 PM

Page 2

**Work Order ID:** 85191**\*85191\***  
**\*D350-636-215\*****Parent Item:** D350-636-215**Parent Item Name:** Skidtube STD LH, Deluxe**Start Date:** 04/06/2012**Required Date:** 18/06/2012**Start Qty:** 1.00**Required Qty:** 1.00

D350-636-109

Manufactured No

110

Each

1.0000

1

1

\*\*

B7158 (x1) Del n/a 31

**\*D350-636-109\***

Tow Ring Installation

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG120	1	
77083	1	

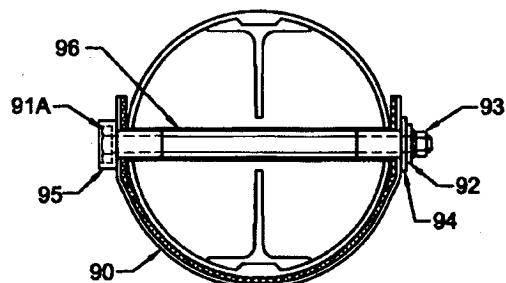
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

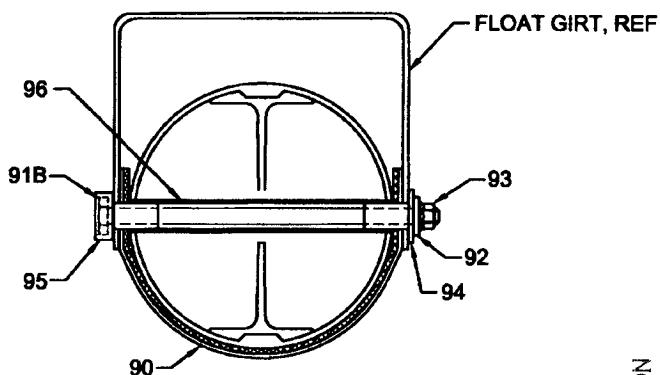
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**WITHOUT APICAL CYLINDRICAL BAG FLOATS**

**OR**



**WITH APICAL CYLINDRICAL BAG FLOATS**

**SECTION T-T**  
**D350-636-015/-016/-215/-216 SKIDTUBES**  
**1 PL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85191  
12104  
104

\* COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR  
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: I  
Date: 10.10.25

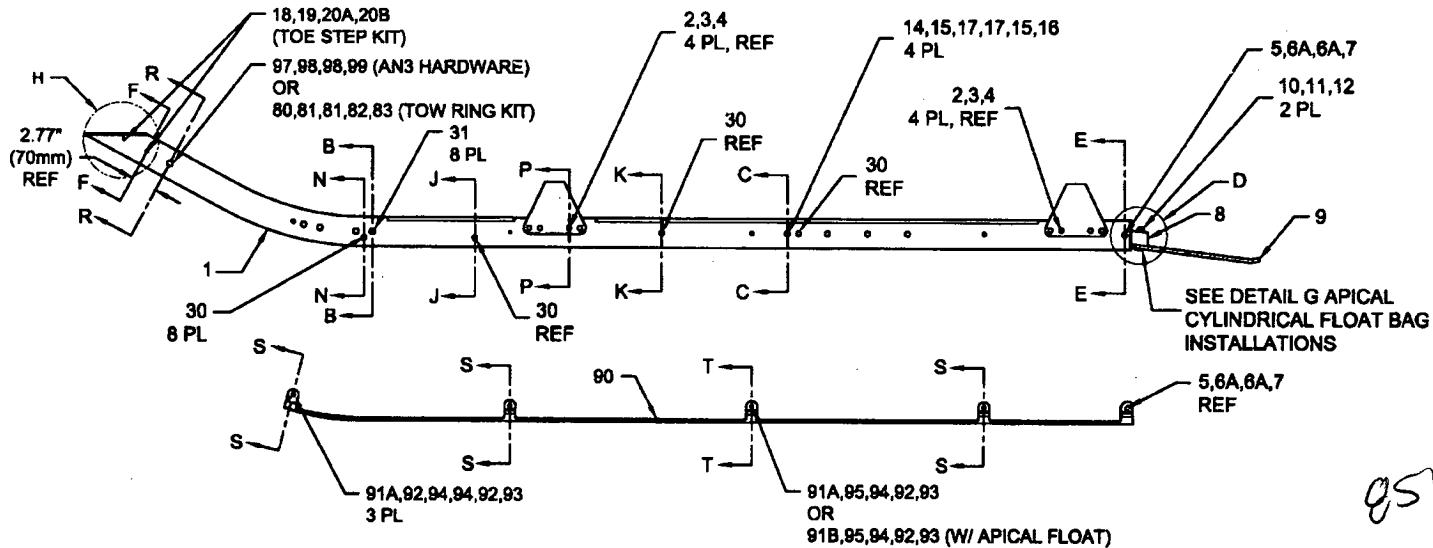
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

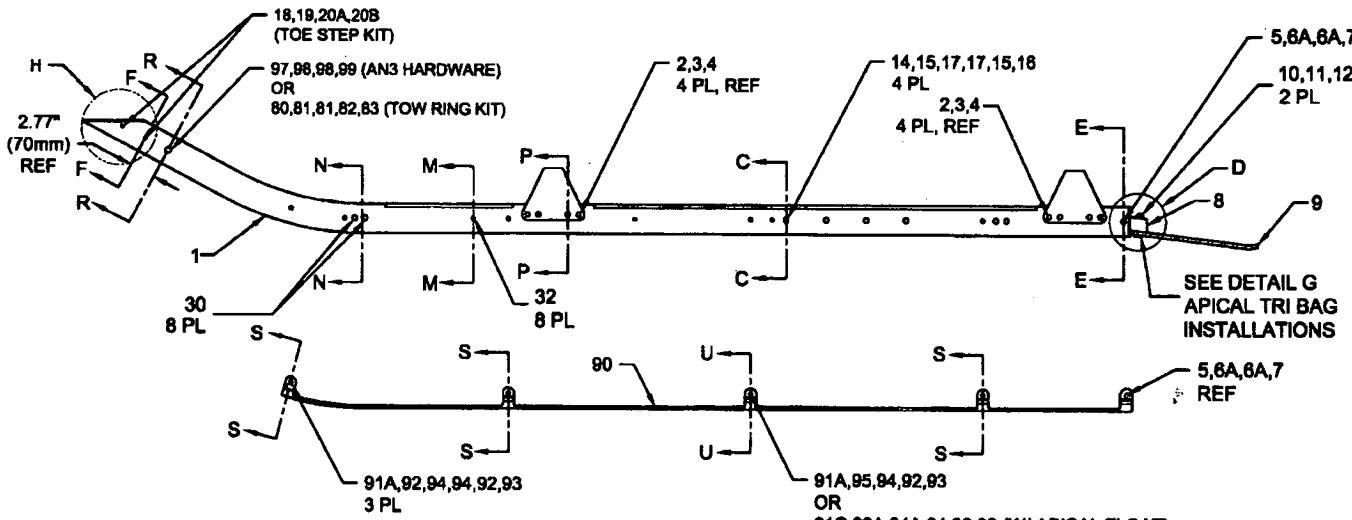
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Figure 3: D350-636-015/-016/-215/-216 SKIDTUBE ASSEMBLY**



**D350-636-015/-016/-215/-216**  
(Aerazur/Apical Cylindrical)



**D350-636-017/-018/-217/-218**  
(Aircruiser/Apical Tri-bag)

Revision: I  
Date: 10.10.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries